

Date: Friday, 30/05/2008 10:13:13 AM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	OUTER AFT SADDLE
<b>Job Number</b> :	39605		
<b>Estimate Number</b> :	11080		
<b>P.O. Number</b> :		<b>Part Number</b> :	D5955
<b>This Issue</b> :	30/05/2008	<b>Drawing Number</b> :	D5955 REV B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	39198	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	15/06/2008
<b>Checked &amp; Approved By</b> :	JLD 08.5.30	<b>Qty:</b>	6
<b>Comment</b> :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec	<b>Um:</b>	Each
<b>Type</b> :	MACHINED PARTS		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101013	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
D6101-013 (7075-T7351)  
Size 2.50" x 10.10" X 8.25" (Grain along 10.10")  
Batch: B 38696

25 08/06/05 (6)

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

25 08/06/05

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

25 08/06/05

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

25 08/06/06

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

212/FL 08/06/09 (6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:13 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 39605

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M107925



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:15 PM  
320 OF  
1:45 PM

M-1

08/06/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FR

08/06/09

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57421

08/06/10

(6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-06-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 391605
<b>Description:</b> Outer Aft Saddle		<b>Part Number:</b> D5955
<b>Inspection Dwg:</b> D5955	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.001	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.321	.321	.321	.321		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.051	3.051	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.505	.500	.500	.500		
M	0.490	0.510		.503	.503	.504	.505		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.002	8.002	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.501	.501	.500	.500		
T	1.625	1.645		1.633	1.634	1.631	1.635		
U	2.000	2.020		2.002	2.005	2.007	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>SP</i>
Date: <i>08/06/05</i>

Audited by: <i>SA</i>
Date: <i>08/06/06</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39605
<b>Description:</b> Outer Aft Saddle		<b>Part Number:</b> D5955
<b>Inspection Dwg:</b> D5955	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
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L	0.495	0.505		.500	.500				
M	0.490	0.510		.505	.505				
N	1.865	1.885		1.875	1.875				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.501	.497				
T	1.625	1.645		1.634	1.635				
U	2.000	2.020		2.005	2.005				
V	0.023	0.043		.033	.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

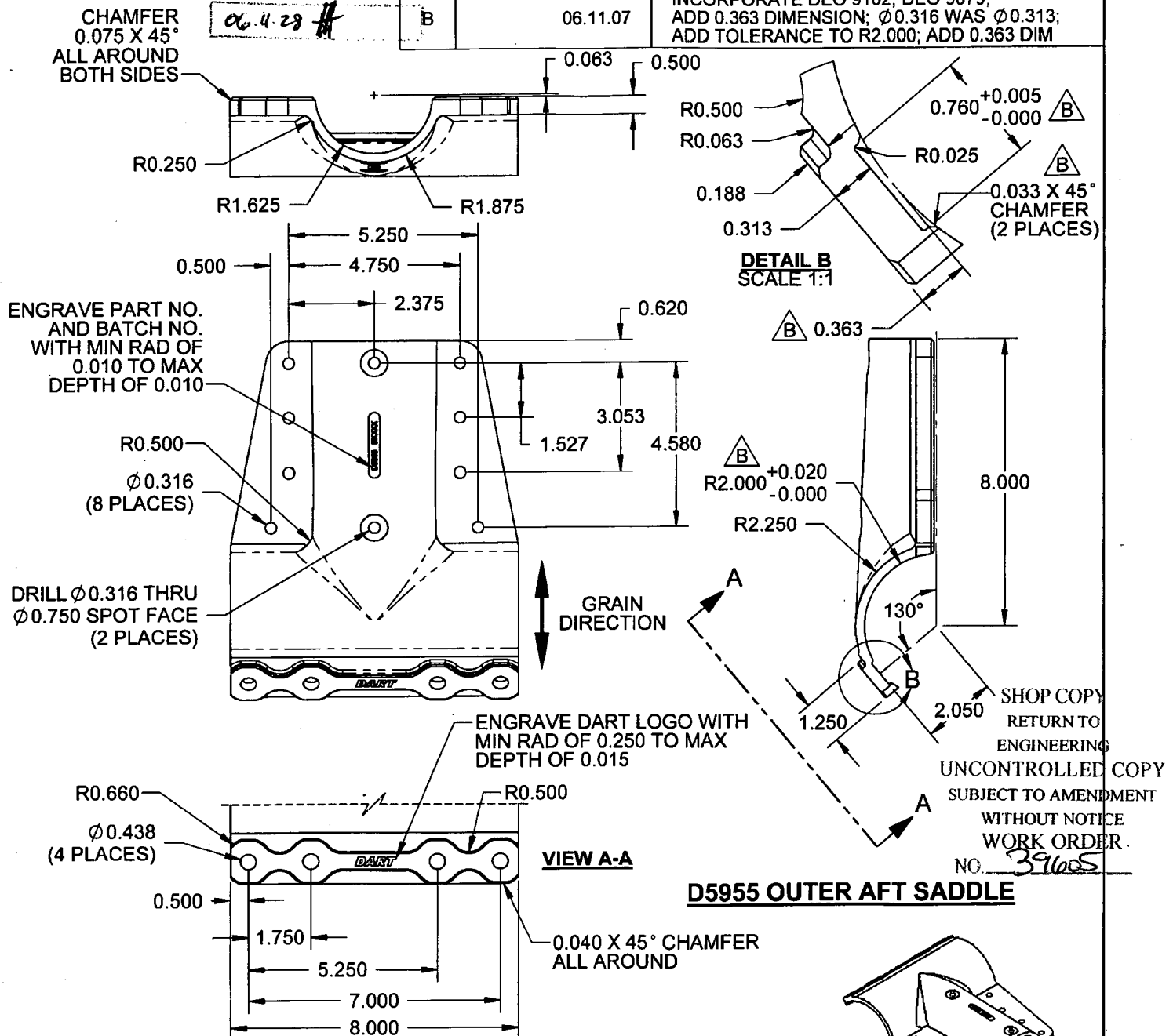
Measured by: S4
Date: 08/06/05

Audited by: SA
Date: 08/06/06

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
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F	08.04.21	Dimension E revised	KJ/DD	

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5955</b>
DATE <b>06.11.07</b>	TITLE <b>OUTER AFT SADDLE</b>	REV. B SHEET 1 OF 1
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>
REV <b>B</b>	DATE <b>06.11.07</b>	DESCRIPTION <b>INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM</b>

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8

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